

Date: Monday, 11/6/2006 1:49:19 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB		
Job Number	: 29316					
Estimate Number	: 10498					
P.O. Number	: N/A			Part Number	: D2739	
This Issue	: 11/6/2006		S.O. No. : N/A	Drawing Number	: D2739 REV C	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : LANDING GEAR	Drawing Revision	: C	
Previous Run	: 29041			Material	: N/A	
Written By	: <i>[Signature]</i>			Due Date	: 11/30/2006	
Checked & Approved By	: <i>[Signature]</i>			Qty:	4	
Comment	: Est Rev: C 02.11.28 Reformat KJ			Um:	Each	
	: Est Rev: D 06-03-21 As Per Rev C JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26005108	Extrusion 'I Beam' thin	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion 'I Beam' thin	
		Pick: Qty Part Number Description Batch 1 D2600-5 Web <i>B24410 m-k 06/11/13 ④</i>	
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2739. <i>m-k 06/11/13 ④</i>	
		2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 <i>m-k 06/11/13 ④</i>	
		3-Use uni-bit to open holes to finish size as per Dwg D2739. <i>m-k 06/11/14 ④</i>	
		4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends. <i>m-k 06/11/14 ④</i>	
		5-Dburr <i>m-k 06/11/14 ④</i>	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP <i>DP 6-11-20</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/14/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEB
Job Number: 29316		Part Number: D2739
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
4.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>M.L 06/11/14 ④</i>		
5.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>NP C-11-20 ④</i>		
6.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.		
Identify and Stock Location: <i>LG</i> <i>NP 6-11-20 ④</i>		
7.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE <i>NP 06/11/20 ④</i>		
Job Completion 		<i>U 06.11.20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

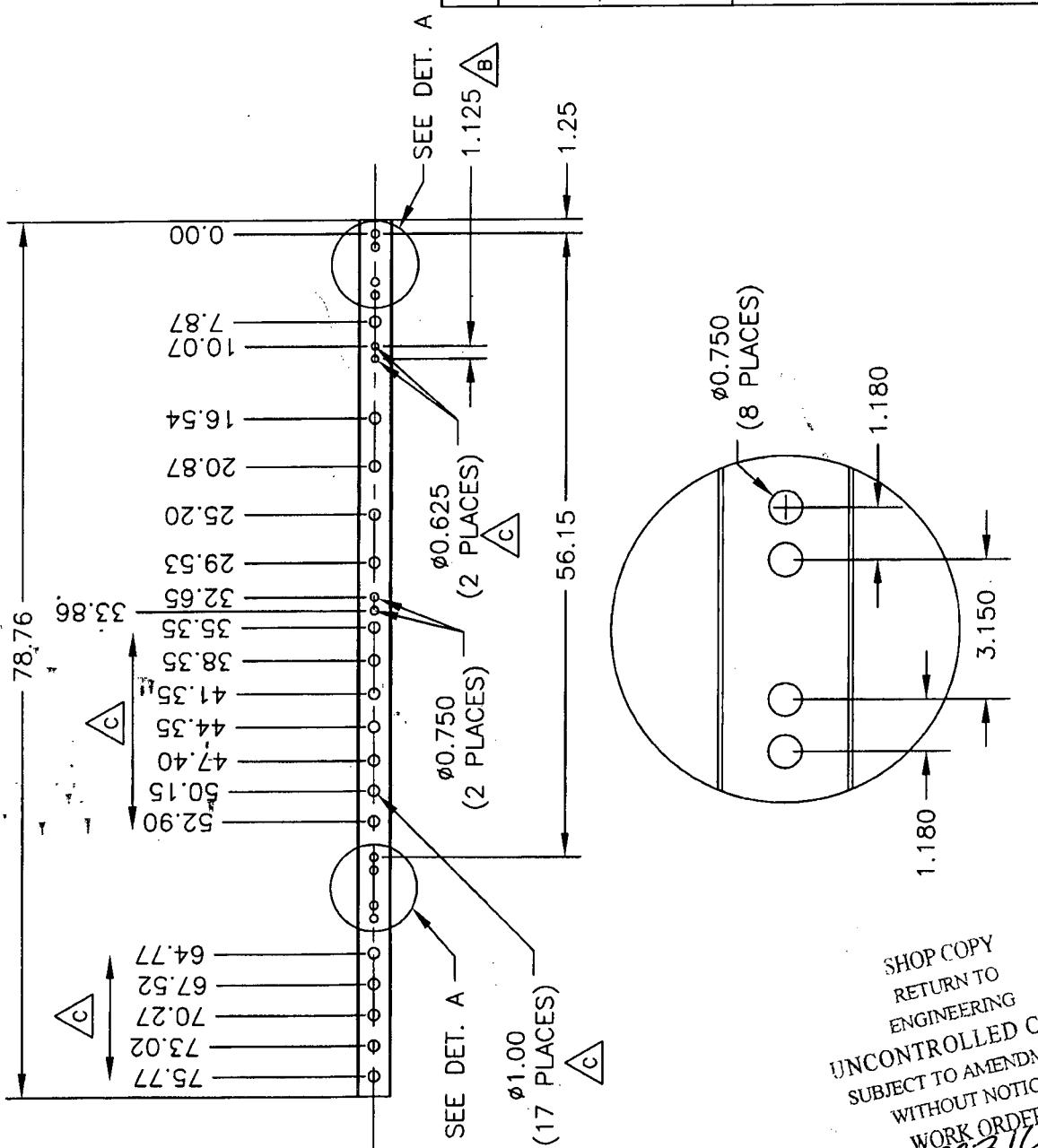
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN R4	DRAWN BY R4	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2739	REV. C SHEET 1 OF 1
DATE 06.01.05		TITLE WEB	SCALE 1:15
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	

**RELEASED**  
06.02.05

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29316

D2739 WEB

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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